

Date: Wednesday, 1/4/2006 2:37:13 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 25395B		
Estimate Number	: 10353		
P.O. Number	: N/A	Part Number	: D2278
This Issue	: 1/4/2006 S.O. No. : N/A	Drawing Number	: D2278 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 25089B	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/25/2006
Checked & Approved By	: <u>SEE ABOVE USER</u>	Qty:	40 Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s) *M19729 = 1837.5 inch² 276*
Material: 5052-H32 sheet (QQ-A-250/8) 0.080" Thick
(M5052H32S.080)
Identify as D2278
Batch: *M 19052 = 1989.4 inch²*

2.0	SHEAR	SHEAR
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Comment: SHEAR
Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg *ml 06/02/14 40*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2278, use stack of 10 *ml 06/02/14 40*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE *ml 06/02/14 40*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK *MS 06/02/15 40*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 17 Date: 26/02/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 06/02/18

40

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/18

40

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-2-20 40

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/02/23

40

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/23 40

Job Completion



U 06-02-23

W/O: _____		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25395B
Description: Leg		Part Number:	D2278
Inspection Dwg: D2278 Rev: C			Page 1 of 1

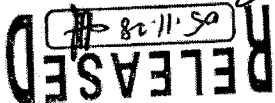
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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[illegible]

Measured by:	<i>JML</i>	Audited by:	<i>J.L</i>	Prototype Approval:	N/A
Date:	<i>06/02/14</i>	Date:	<i>06-02-14</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	



1) MATERIAL:



(REF DART SPEC M5052H32S.080)

2) FINISH:

ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) ALL DIMENSIONS ARE IN INCHES

4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWN BY BH	APPROVED 	CHECKED 
REV. D	D2278	SHEET 1 OF 1	
TITLE		SCALE	
LEG		1:2.5	
CHANGED RADIUS TO 0.354		05.11.14	
ADD FINISHING NOTE		05.11.14	

DART

